

54346 - Deriv

Work Order ID 53705

November 17, 2009 10:31:29 AM



Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

S 02/12/03

for BG 09/11/27

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

m111311

m111494

09.11.23

10

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:33 AM



Page 2

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

PD 09.11.23 (15)

130 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

278 09/11/23

EH
(XO) /

140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

09.11.23

10 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:39 AM



Page 3

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7m k out ul 24

10x

2

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 1111311

6-Grind End Plate flush

7-Install last rivet as per Dwg.

09.11.24

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:39 AM

Page 4

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00

Required Date: 11/20/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PD 09.11.24

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> Sorlu/zt

X10RH/

210

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

=> M 09/11/25

X10BH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:40 AM



Page 5

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30AM

=> 9/09/11/25

X10/17

230

Wing Walk as per dwg QSI005 4.4 Batch M10623

0.00



HandFinish

Memo

0.00

Hand Finishing

MO 09/11/26

X10

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-11-26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:44 AM



Page 6

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u> </u>								

9/12/09 (102) Suf

(KORR) /

Ref/12/4 (10)

1923

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53705

November 17, 2009 10:31:45 AM



Page 7

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08 *[Signature]*

MF 09-12-08

Picklist Print

November 17, 2009 10:31:11 AM

Page 1

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-041RevB

Manufactured

No

Each

72.0000

10.0000



Step Leg Assembly Hi

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

53523

32

Main Warehouse

WA

40

52104

40

D3066-1RevB

Manufactured

No

Each

101.0000

20.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

101

51545

14

52662

87

D3219-1RevA

Manufactured

No

Each

68.0000

20.0000



Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

68

52230

68

11/19/24

10
11/19/24

20
11/19/23

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:12 AM

Work Order ID: 53705



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA		Manufactured	No			110	Each	97.0000	10.0000			
End Plate												

09.11.23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	97	
51546	8	
53451	89	

D3272-1RevB		Manufactured	No			110	Each	0.0000	10.0000			
Step												
MS21042L5		Purchased	No			110	Each	926.0000	20.0000			
Nut												

09.11.19 353761

9/12/11 10x

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	926	
110382	10	
111127	4	
111636	15	
112314	897	

20 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:12 AM

Page 3

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	2,015.000	160.0000			
												
Rivets												

11/17/09

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2015	
110731	215	
111359	46	
111477	74	
112314	1656	
112385	24	

160

AN3-35A
Bolt

Purchased	No		260	Each	421.0000	20.0000
						

9/12/11

100 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	421	
106993	12	
110467	1	
112314	408	

20 SP

November 17, 2009 10:31:12 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

November 17, 2009 10:31:13 AM

Work Order ID: 53705



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-13A		Purchased	No			260	Each	299.0000	80.0000			
---------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

5-10 Bolt

9/12/11 SP
(100)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	299	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	7	
112314	48	
113149	100	
17406	0	
51764	0	

M 113226
M 113359
9/12/11 SP

39X
41X

November 17, 2009 10:31:13 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:13 AM

Work Order ID: 53705



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-36A		Purchased	No			260	Each	351.0000	20.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>640 Bolt</p> </div> <div> <p>9/12/11 sf</p> </div> </div>												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	351	
109545	11	
110467	7	
110731	4	
112243	20	
112314	259	
112385	50	

AN960JD10		Purchased	No			260	Each	2,498.000	40.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>Washer</p> </div> <div> <p>9/12/11 100 SF</p> </div> </div>												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	2498	
105442	19	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	965	
112369	218	
113149	1000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

November 17, 2009 10:31:14 AM

Work Order ID: 53705



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

nl6

Purchased

No

260

Each

3,603.000

160.0000



Washer

9/12/11 (10K) SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3603

108161

329

110523

340

111279

101

111916

482

112314

2351

16941

0

160 SP

November 17, 2009 10:31:14 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:15 AM

Page 7

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516	84	Purchased	No			260	Each	1,692.000	40.0000			

Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1692	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	64	
112314	282	
<u>112828</u>	500	
113149	500	

alish sp
10x

40x sp

November 17, 2009 10:31:15 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:16 AM

Page 8

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3RevG

x4

Manufactured

No

260

Each

169.0000

40.0000



5
f10

Lug

9/12/1

SP
12/1

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51568

3

Main Warehouse

ST176

166

51428

166

D2618RevB1

x2

Manufactured

No

260

Each

251.0000

20.0000



5
f10

Bushing

2x

40SP

9/12/1 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

251

50989

200

~~51189~~

51

15 SP
5x51

November 17, 2009 10:31:16 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:22 AM

Page 9

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA *+2 @ 7.20"* Manufactured

No

260

f

360.0237

6.0000



Abraison Strip

albi sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST403

360.0236842

50593

144.023684

52563

216

D3067-1RevA

Manufactured

No

260

Each

97.0000

10.0000



End Plate

2x

11.09.11.24

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

97

51546

8

53451

89

D3235-1RevA *+2*

Manufactured

No

260

Each

93.0000

20.0000



Mounting Lug

10

9/12/11 sf (12x)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

93

45398

4

47969

89

20 sf

November 17, 2009 10:31:22 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:23 AM

Page 10

Work Order ID: 53705

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC, <i>41</i>		Manufactured	No			260	Each	73.0000	10.0000			

S
41 Support Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

52075

73

Purchased

No

260

Each

3,038.000

20.0000

9/12/11 *SP*

MS21042L3 *22*

S
22 Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

1000

9/12/11 *SP* *(14)*

2000

November 17, 2009 10:31:23 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:31:28 AM

Work Order ID: 53705



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/17/09

Required Date: 11/20/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			260	Each	5,129.000	80.0000			



Nut

9/12/11 (10x 50)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5129	
110507	184	
111827	4938	
112314	7	
15924	0	

80 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *53705*

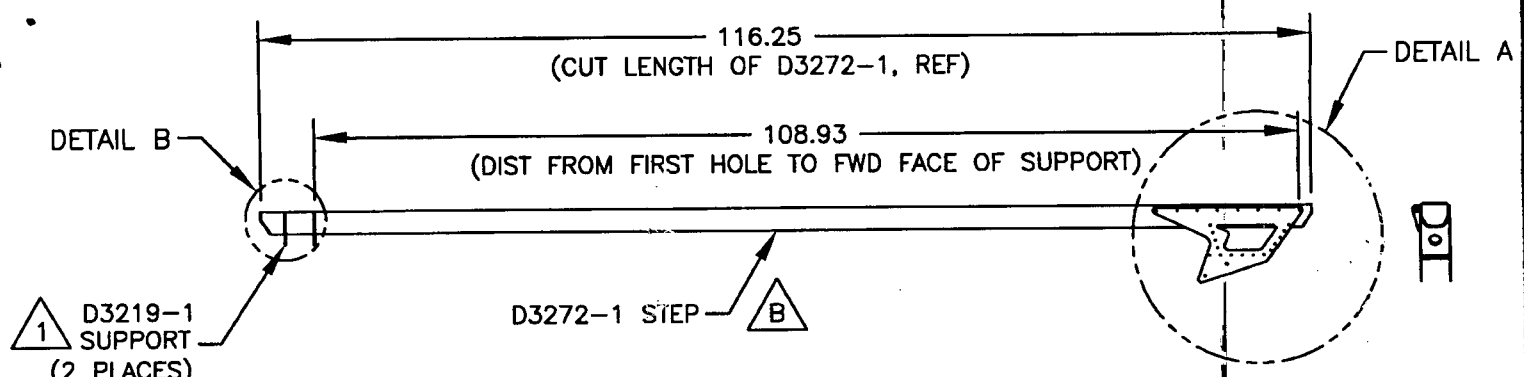
*BH 09-10-22***Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

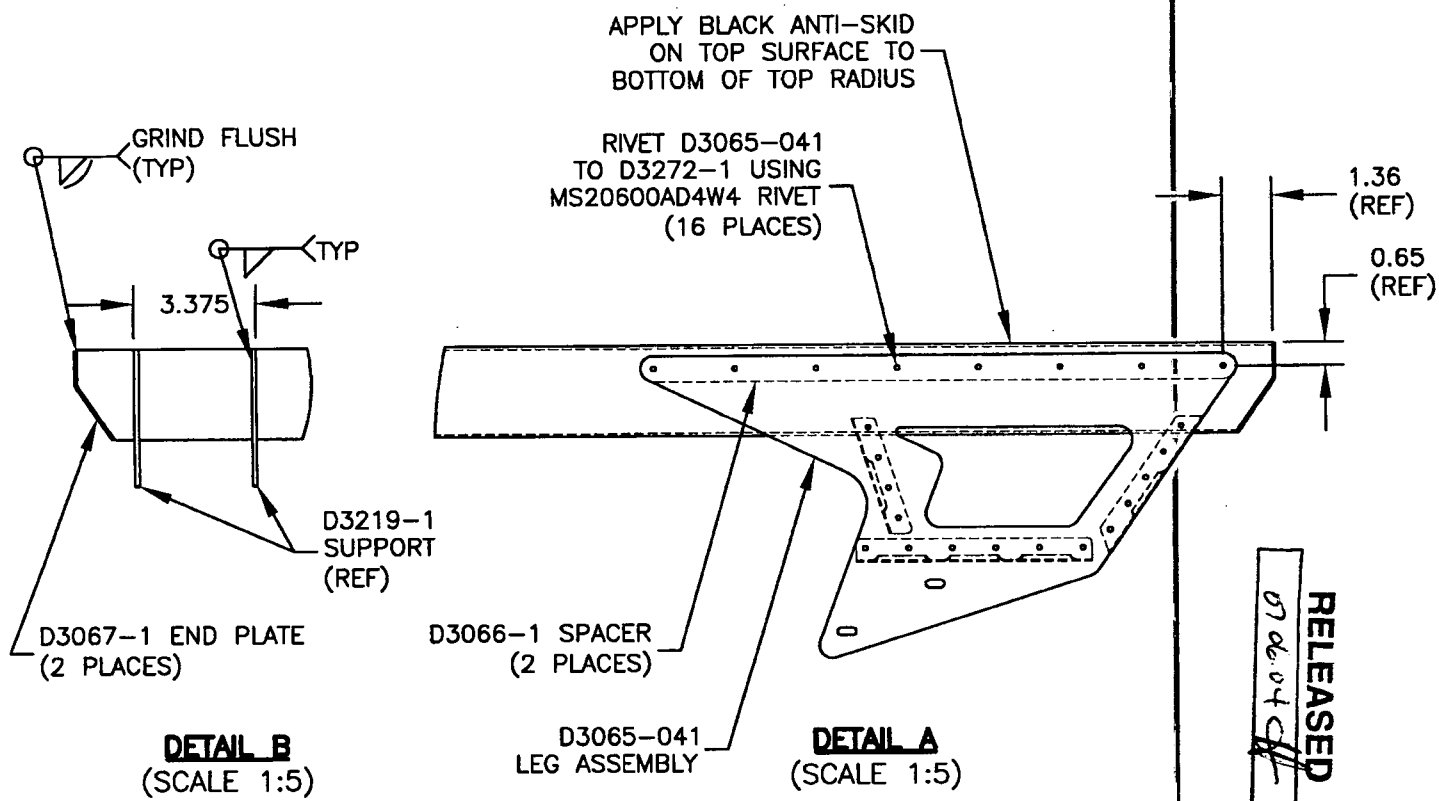
DART

UNCONTROLLED COPY
 WITHOUT NOTICE
 WORK ORDER
 NO. 53705

DESIGN	90	DRAWN BY	18	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	Le	APPROVED	18	REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE
				1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
 D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
 (SCALE 1:5)

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

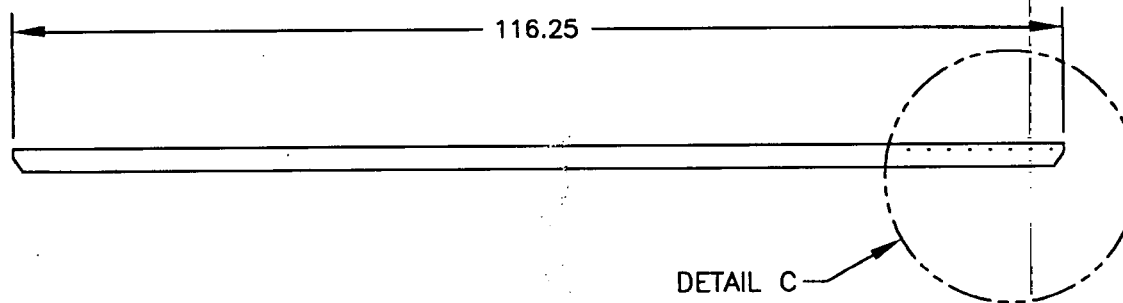
Copyright © 2004 by DART AEROSPACE LTD

DART

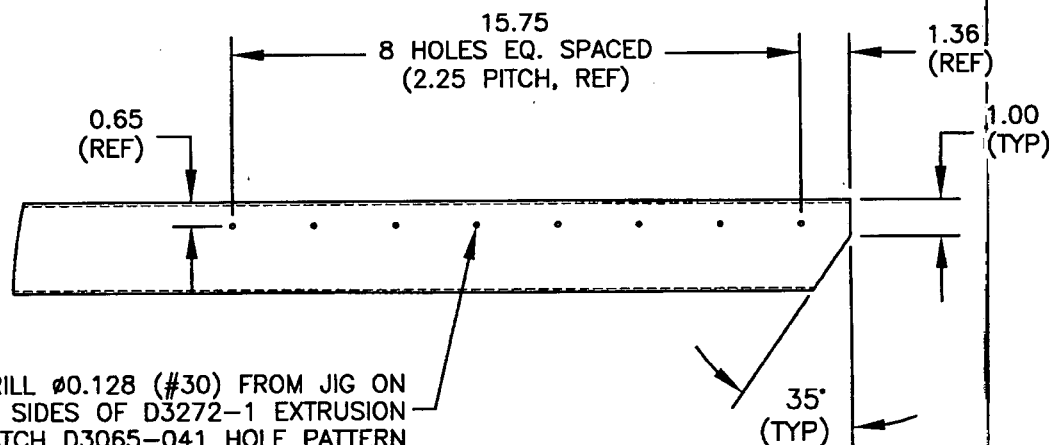
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 07.05.18	DRAWING NO. D3272	REV. B
	TITLE STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
		SCALE 1:20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53705

RELEASED
07.06.04



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer, and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

53705

• COPYRIGHT © 1993 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G
Date: 08.10.06